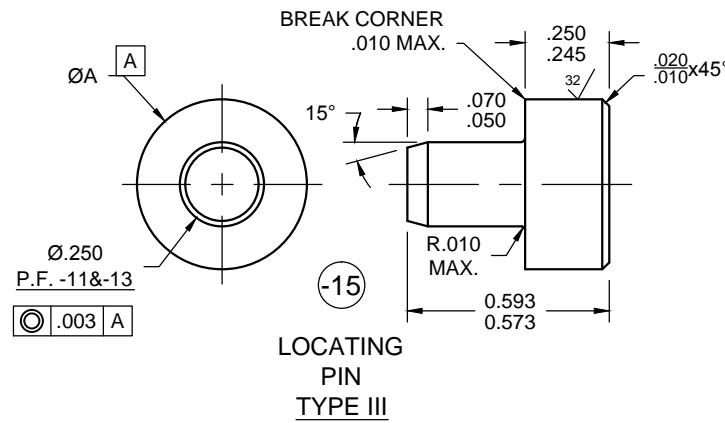


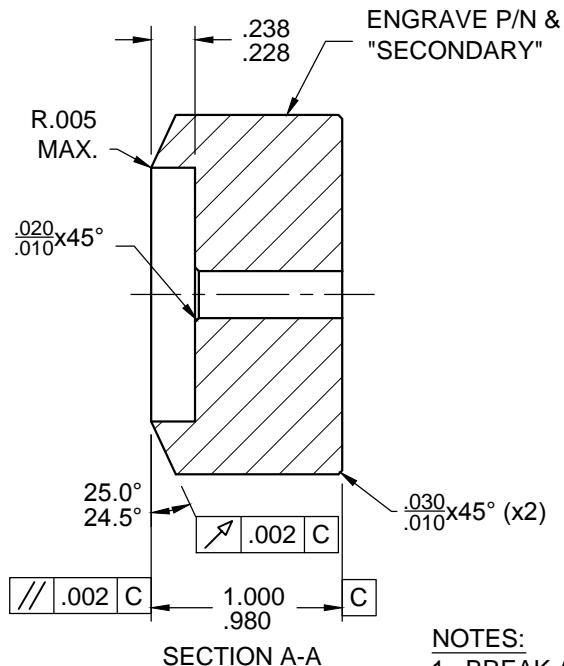
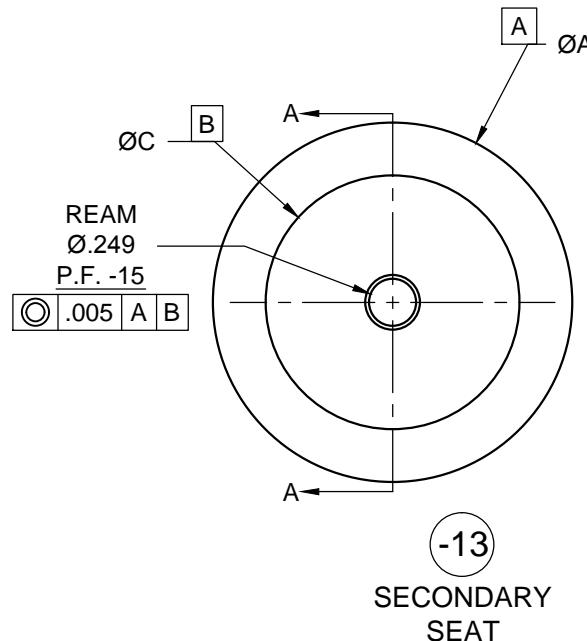
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW
6	-15 DELETED LOCATING PIN TYPE I PER. R.W.	9/10/13	CFS GE
7	-15 RBST2128 CH'D MATERIAL SIZE FROM Ø5/8 X 5/8 TO Ø3/4 X 5/8 & RBST2162 FROM Ø3/8 X 5/8 TO Ø1/2 X 5/8.	11/5/13	JAG GE



TOOL #	ØA +.000 -.002	PIN TYPE	QTY.	MATERIAL
RBST2120	.310	III	2	1018 RND. BAR Ø3/8 x 5/8
RBST2128	.622	III	1	1018 RND. BAR Ø3/4 x 5/8
RBST2162	.372	III	1	1018 RND. BAR Ø1/2 x 5/8

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1		DRAWN BY: PERRITT APPROVED <i>D. Weil</i>
HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1		FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SCALE NTS DATE 1-23-08 SHEET 9 of 9

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



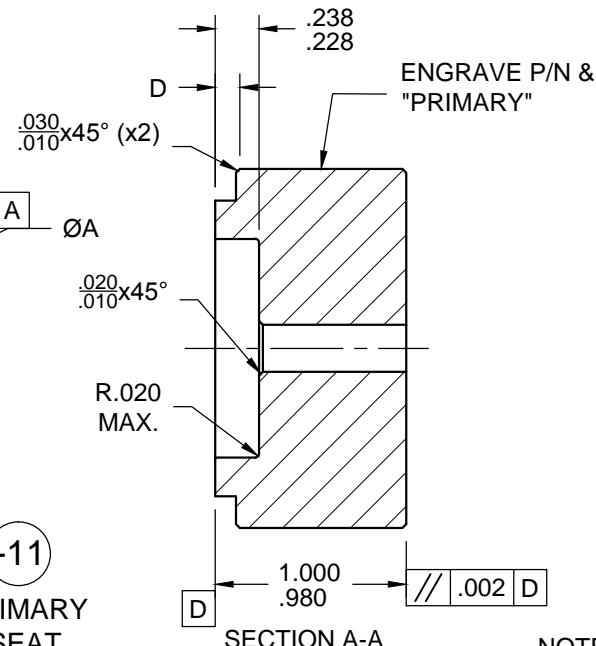
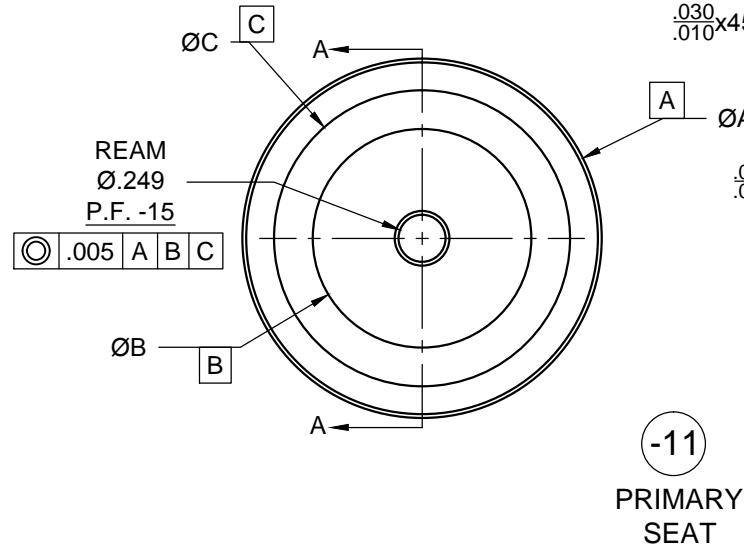
NOTES:

1. BREAK ALL SHARP CORNERS (.015/.03).

RED BARN MACHINE	
TITLE	RBST2100 SERIES TRI-ROLLER SWAGING TOOL; SECONDARY SEAT
DWG NO.	TOOL# (see chart)-13
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 FRACTIONS ± 1/32 XX ± .01 ANGLES ± 5° X ± .1	
DRAWN BY: PERRITT APPROVED D. Weil HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
SCALE	NTS
DATE	1-23-08
SHEET	8 of 9

TOOL #	QTY.	ØA +.000 -.030	ØC +.000 -.005	MATERIAL
RBST2120	1	1.360	.968	4140 Q&T RND. BAR Ø1-3/8 x 1-1/8
RBST2128	0	0	0	NONE
RBST2162	0	0	0	NONE

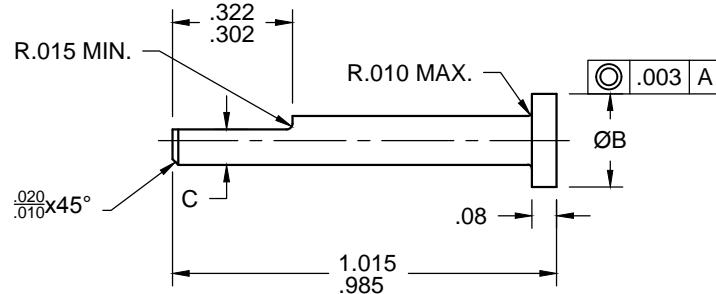
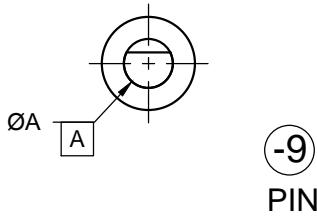
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



TOOL #	ØA .030 +.000 -.005	ØB .005 +.000 -.002	ØC .002 +.002 -.002	D .002 +.002 -.002	MATERIAL
RBST2100	1.360	.875	0	0	4140 Q&T RND. BAR Ø1-3/8 x 1-1/8
RBST2128	1.870	1.139	0	0	4140 Q&T RND. BAR Ø1-7/8 x 1-1/8
RBST2162	1.485	.881	1.183	.053	4140 Q&T RND. BAR Ø1-1/2 x 1-1/8

TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; PRIMARY SEAT		REV 7
DWG NO. TOOL# (see chart)-11		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
TOLERANCES ON: DECIMALS XXX ± .005 FRACTIONS ± 1/32 XX ± .01 ANGLES ± .5°		
APPROVED BY: PERRITT <i>D. Weil</i>		
HEAT TREAT		
FINISH SPEC BLACK OXIDE		
USED ON BEARING		
SEE Pg. 1		
SCALE NTS	DATE 1-23-08	SHEET 7 of 9

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



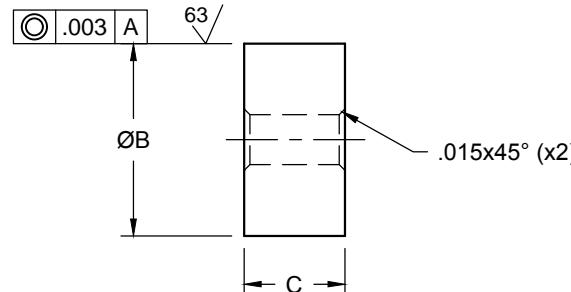
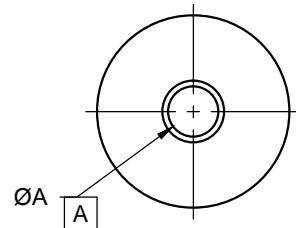
NOTES:

1. BREAK ALL SHARP CORNERS (.015/.03).

RB RED BARN MACHINE	
TITLE	RBST2100 SERIES TRI-ROLLER SWAGING TOOL; PIN
DWG NO.	TOOL# (see chart)-9
REV 7	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
XXX	± .005
XX	± .01
X	± .1
FRACTIONS ± 1/32	
ANGLES ± 5°	
APPROVED <i>D. Weil</i>	
HEAT TREAT	
FINISH SPEC BLACK OXIDE	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	1-23-08
SHEET	6 of 9

TOOL #	ØA +.000 -.001	ØB +.005 -.002	C +.000 -.020	MATERIAL
RBST2120	.129	.188	.104	MCMASTER-CARR PN: 98378A909
RBST2128	.129	.188	.104	MCMASTER-CARR PN: 98378A909
RBST2162	.129	.188	.104	MCMASTER-CARR PN: 98378A909

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



-7

GUIDE

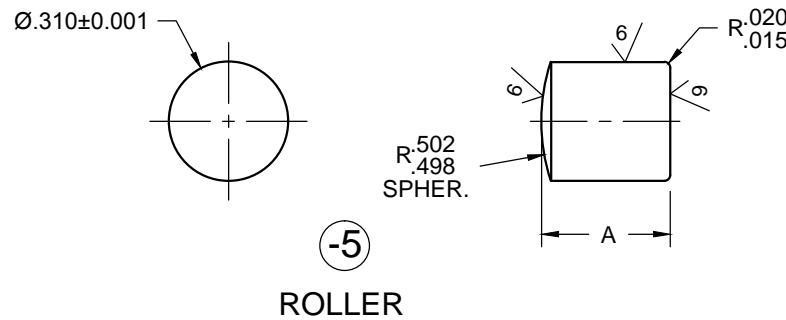
NOTES

- BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +.001 -.001	ØB +.002 -.002	C +.000 -.010	MATERIAL
RBST2120	.131	.310	.390	BRONZE RND. BAR Ø5/16 x 1/2
RBST2128	.131	.622	.312	BRONZE RND. BAR Ø5/8 x 1/2
RBST2162	.131	.372	.312	BRONZE RND. BAR Ø3/8 x 1/2

RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; GUIDE	
DWG NO.	TOOL# (see chart)-7
REV 7	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS .XXX ± .005 FRACTIONS ± 1/32	
XX ± .01 ANGLES ± 5°	
X ± .1	
APPROVED	
HEAT TREAT	
FINISH SPEC	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	1-23-08
SHEET	5 of 9

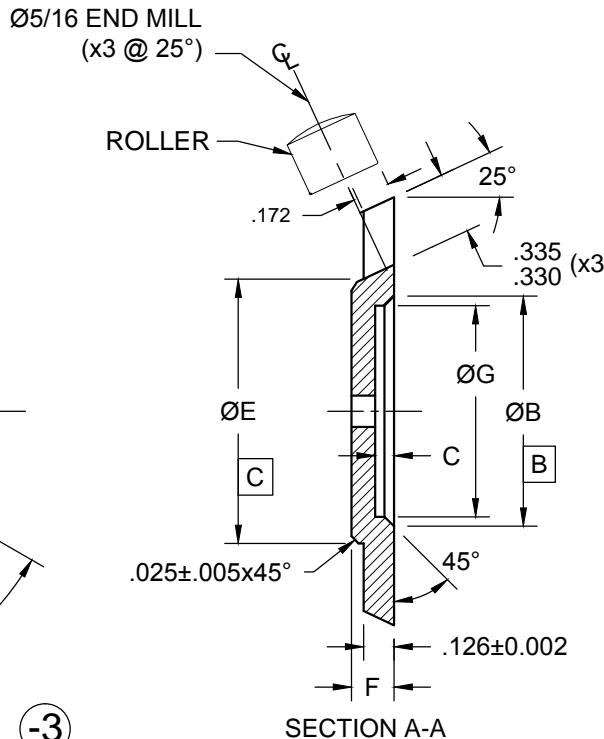
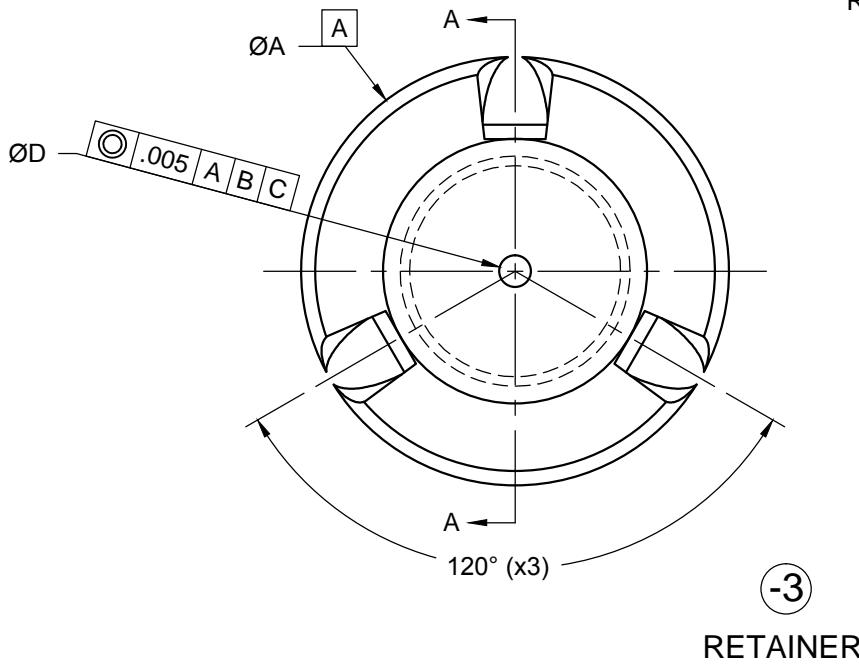
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW



TOOL #	A +.001 -.001	MATERIAL		
RBST2120	.335	.310 MINUS GAUGE PIN	MSC#89031009	
RBST2128	.335	.310 MINUS GAUGE PIN	MSC#89031009	
RBST2162	.335	.310 MINUS GAUGE PIN	MSC#89031009	

RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ROLLER (QTY. 3)	
DWG NO.	TOOL# (see chart)-5
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	DRAWN BY: PERRITT APPROVED <i>D. Weil</i> HEAT TREAT RC 55-60 FINISH SPEC USED ON BEARING SEE Pg. 1
FRACTIONS ± 1/32 XX 15 x 45° PR.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
SHEET 4 of 9	

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW

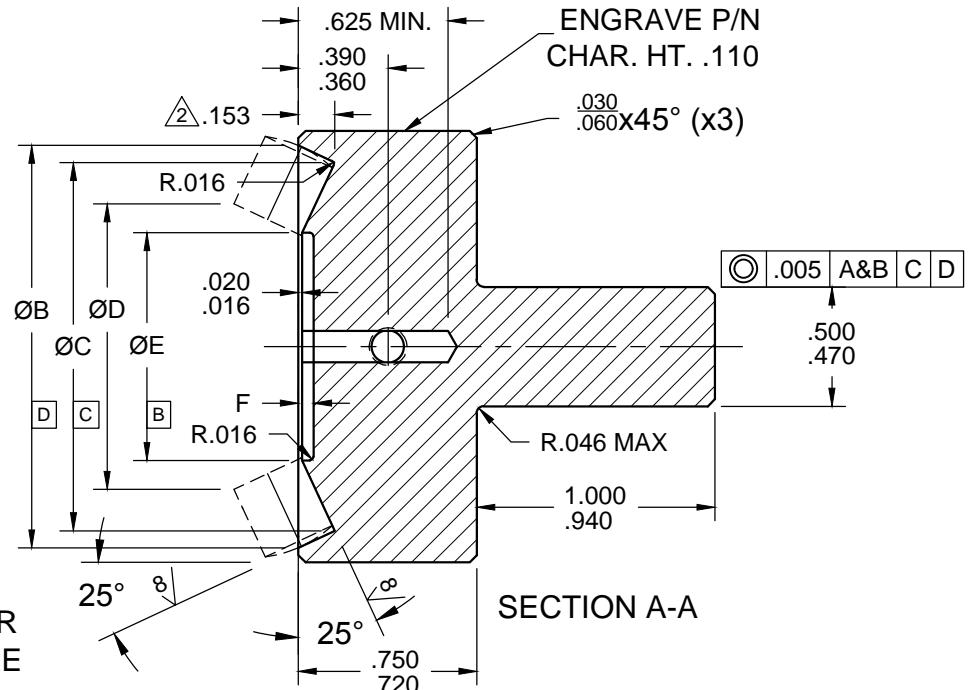
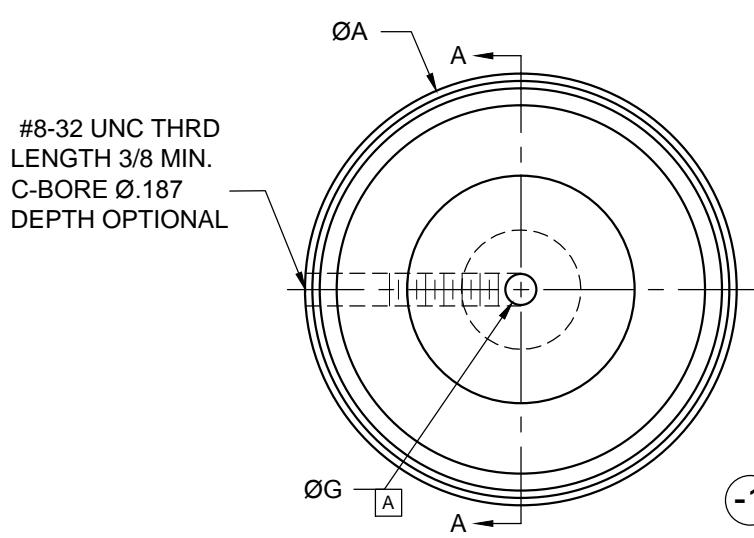


TOOL #	ØA +.002 -.002	ØB +.010 -.005	C +.020 -.000	ØD +.004 -.001	ØE +.000 -.015	F +.010 -.010	ØG +.010 -.005	P.D. REF.	MATERIAL
RBST2100	1.540	.700	.150	.136	.644	.210	.530	.968	BRONZE RND. BAR Ø1-5/8 x 3/8
RBST2128	1.857	1.077	.070	.136	0	0	.937	1.283	BRONZE RND. BAR Ø1-7/8 x 1/4
RBST2162	1.610	.775	.072	.136	0	0	.631	1.025	BRONZE RND. BAR Ø1-5/8 x 1/4

NOTES
1. BREAK ALL SHARP CORNERS (.015/.03).

RED BARN MACHINE		REV
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; RETAINER		7
DWG NO.	TOOL# (see chart)-3	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT
TOLERANCES ON: DECIMALS XXX ± .005 FRACTIONS ± 1/32 XX ± .01 ANGLES ± 5°		APPROVED D. Weil
HEAT TREAT FINISH SPEC		USED ON BEARING
SEE Pg. 1		
SCALE NTS	DATE 1-23-08	SHEET 3 of 9

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028.	9/10/13	CFS GE



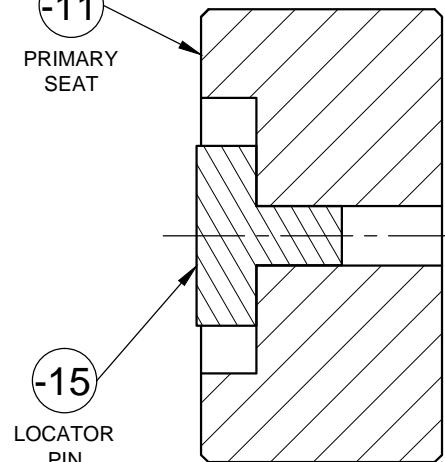
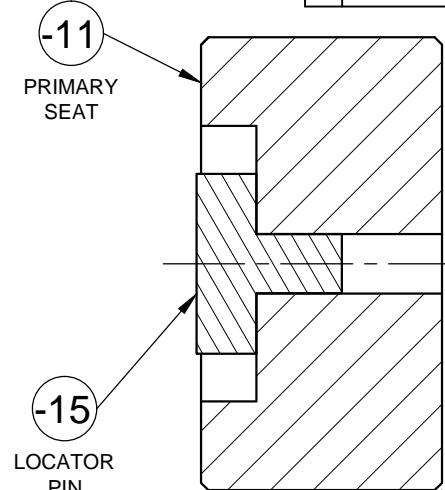
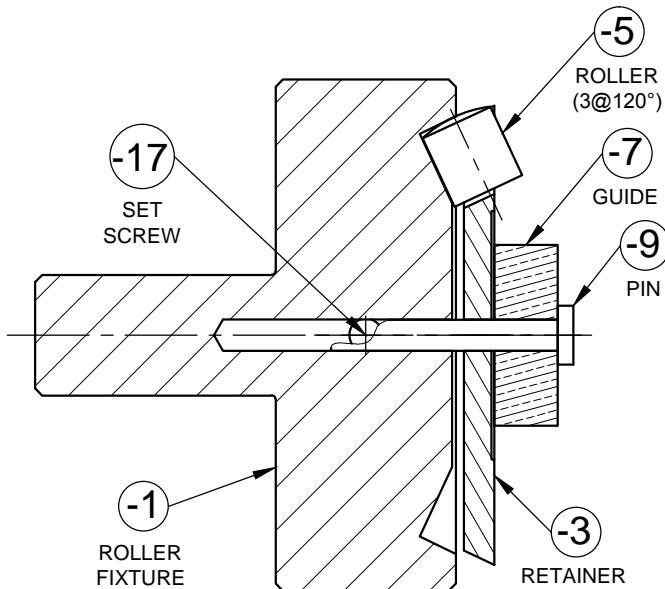
TOOL #	MATERIAL						
	ØA +.000 -.030	ØB +.005 -.000	ØC +.009 -.000	ØD P.D. REF.	ØE +.008 -.000	F +.030 -.000	ØG +.000 -.001
RBST2100	1.735	1.463	1.314	.968	.698	.130	.131
RBST2128	2.000	1.776	1.629	1.283	1.028	0	.131
RBST2162	1.875	1.521	1.375	1.031	.767	0	.131

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).
DIMENSION TO BOTTOM OF R.016=.153;
DIMENSION TO SHARP CORNER=.158.
3. -1 BEARING RACE SURFACES MUST HAVE
SMOOTH APPEARANCE, FREE FROM
MACHINING MARKS AND GROOVES.
4. DO FIRST ARTICLE INSPECTION
BEFORE HEAT TREATING.

RED BARN MACHINE	
TITLE	RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ROLLER FIXTURE
DWG NO.	TOOL# (see chart)-1
REV 7	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS $\pm \frac{1}{32}$
XXX $\pm .005$	XX $\pm .01$
XX $\pm .001$	ANGLES $\pm .5^\circ$
APPROVED <i>D. Weil</i>	
HEAT TREAT RC 55-60	
FINISH SPEC BLACK OXIDE	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	1-23-08
SHEET	2 of 9

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.



REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028. -15 DELETED LOCATING PIN TYPE I PER. R.W.	9/10/13	CFS GE
7	-15 RBST2128 CH'D MATERIAL SIZE FROM Ø5/8 X 5/8 TO Ø3/4 X 5/8 & RBST2162 FROM Ø3/8 X 5/8 TO Ø1/2 X 5/8.	11/5/13	JAG GE

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
406-310-403-101	RBST2120
412-010-427-101	RBST2128
406-312-100-101	RBST2162

NOTES

- 5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8
		-15	1 or 2	LOCATING PIN	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

RED BARN MACHINE	
TITLE	REV
RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ASSEMBLY	
TOOL# (see chart above)	7
DWG NO.	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	DRAWN BY: PERRITT APPROVED: D. Weil HEAT TREAT: LISTED PER ITEM FINISH SPEC: LISTED PER ITEM USED ON BEARING: SEE ABOVE
1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS DATE 1-4-08	SHEET 1 of 9

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPR
—	—	—	—	—

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	RB	RED BARN MACHINE
CHECKED		
HEAT	TITLE	
TREAT		
FINISH		
SPEC		
USED ON MODEL		
?		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	DWG NO.	PART #
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.015 x 45° PR. 0.015 R. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE	NTS
	DATE	1-28-06
	SHEET	1 of 1

4A	CH'D 1/16 FROM R512100.
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028.

TEST SUBJECT APPROVED FOR PRODUCTION

PART #	QTY	DESCRIPTION
-1	1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
-3	1	BRASS RND Ø2 x 5/16
-5	3	0-1 DRILL ROD Ø3/8 x 1/2

DRAWN BY:	PERRITT
APPROVED	RB
HEAT	

NOTES

1. ENGRAVE P/N; CHARACTER H
2. ENGRAVE 'PRIMARY'
3. ENGRAVE 'SECONDARY'

RED BARN MAC